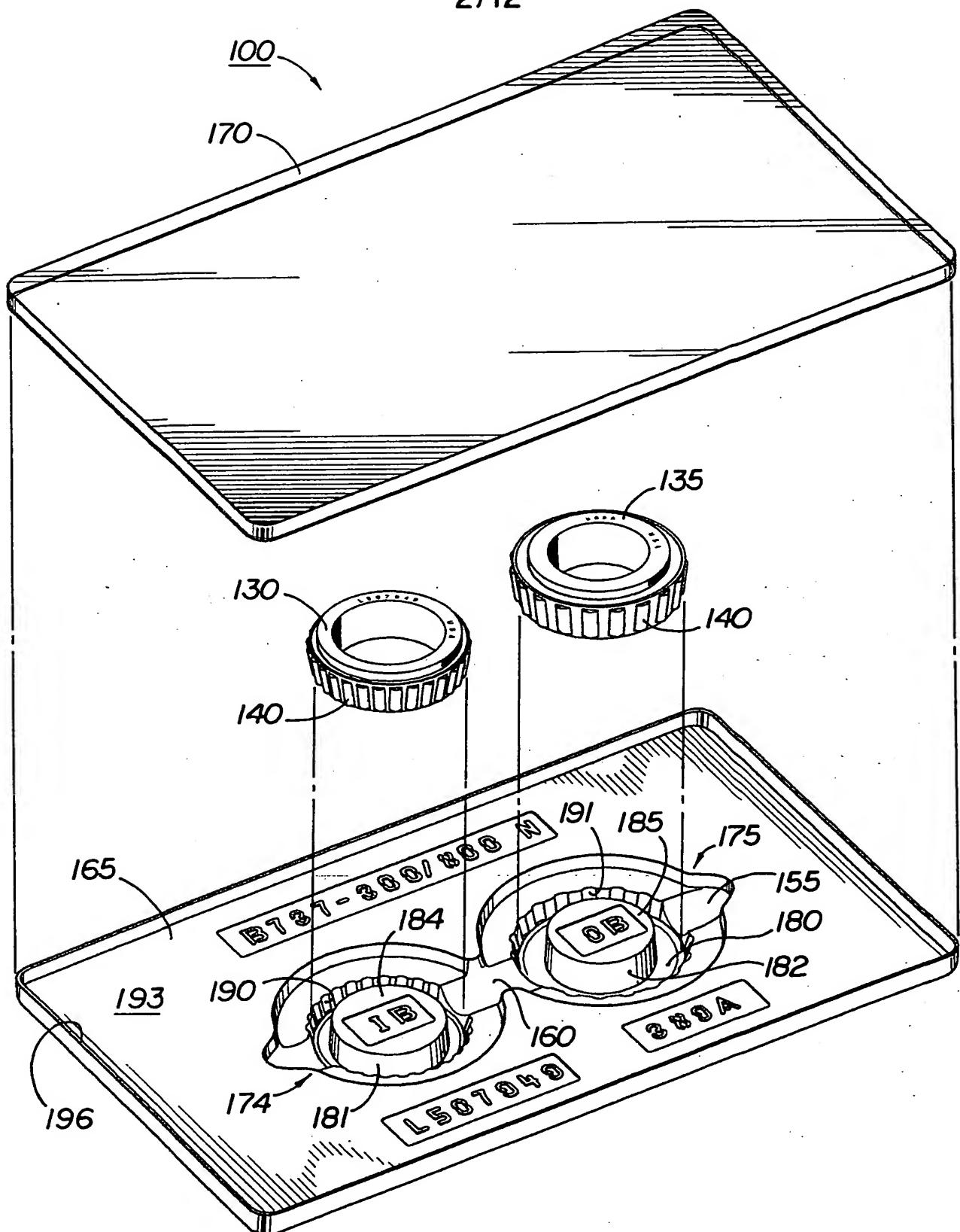
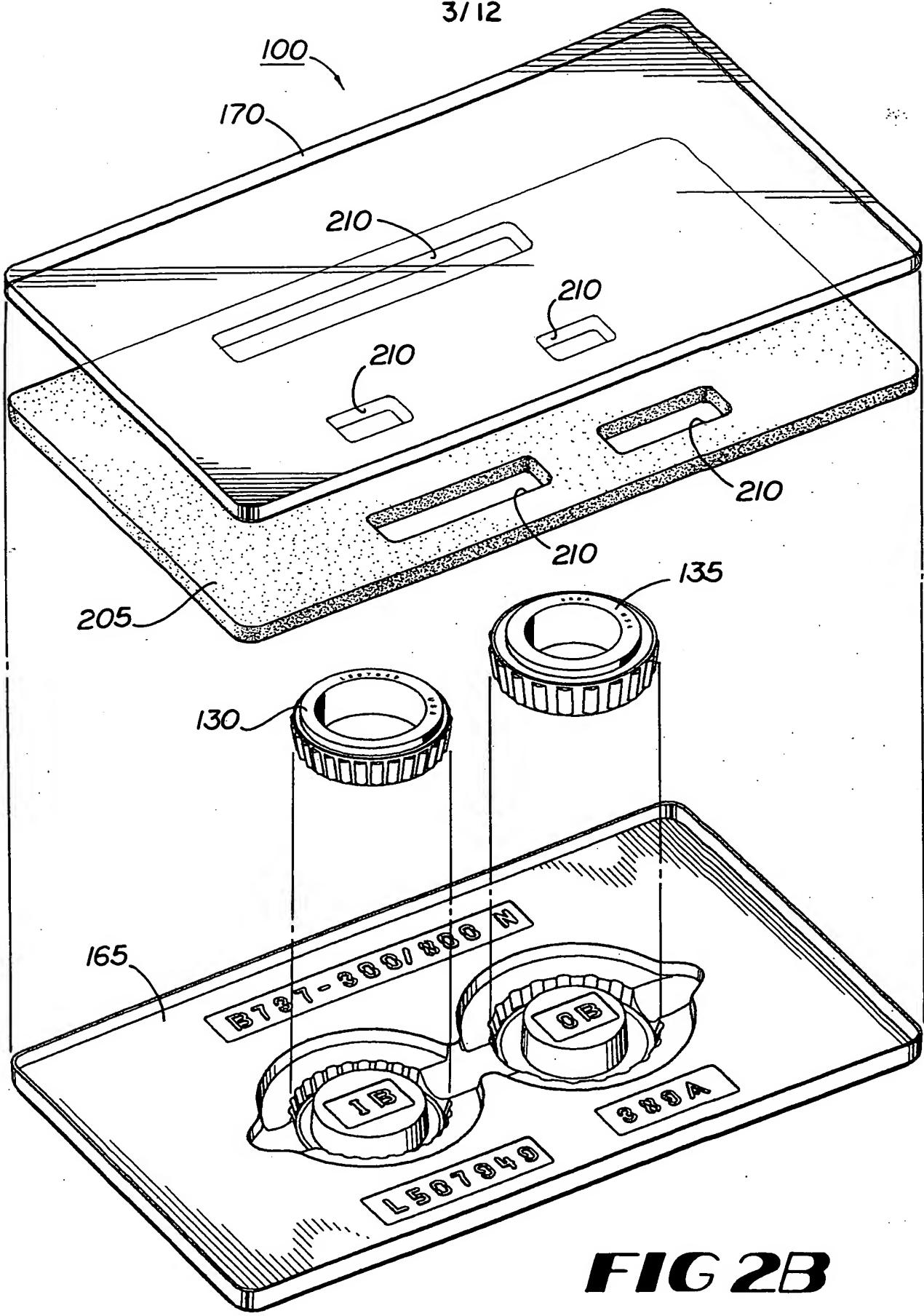


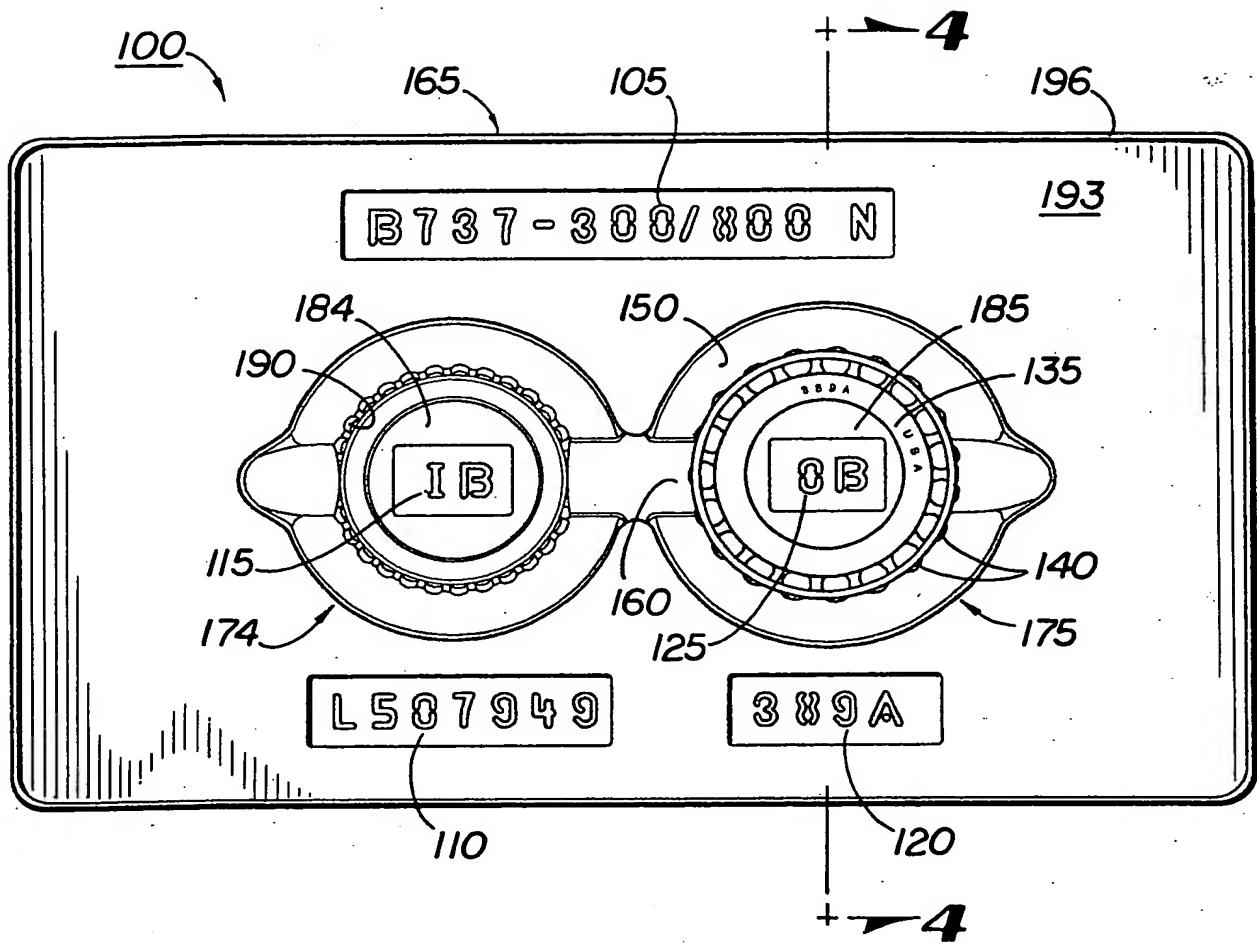
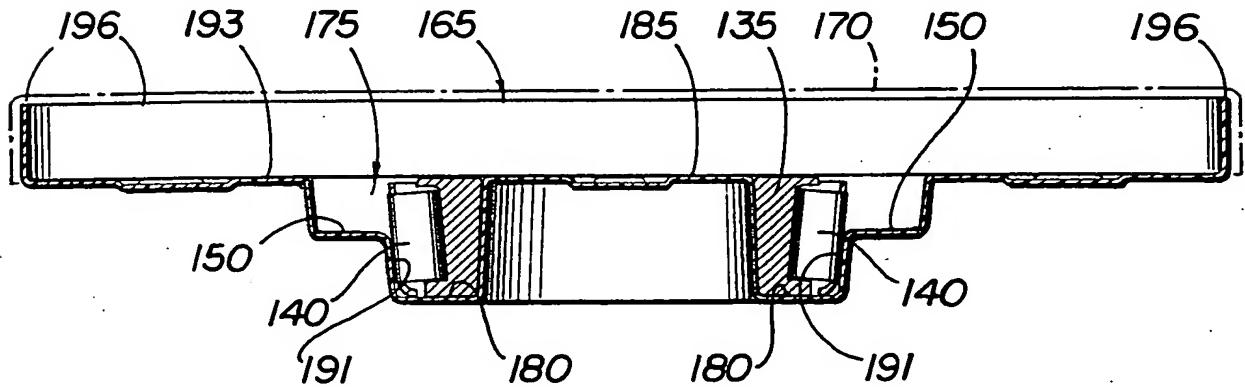
# FIG. 1

**FIG 2A**

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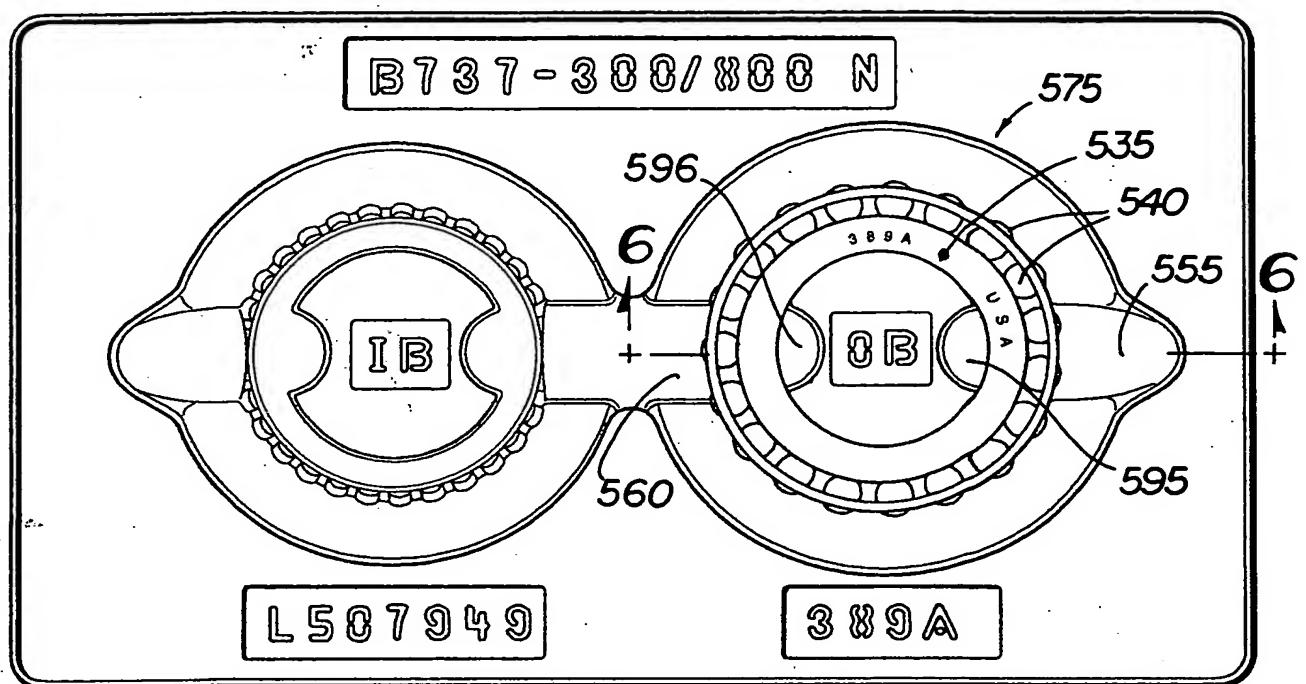


**FIG 2B**

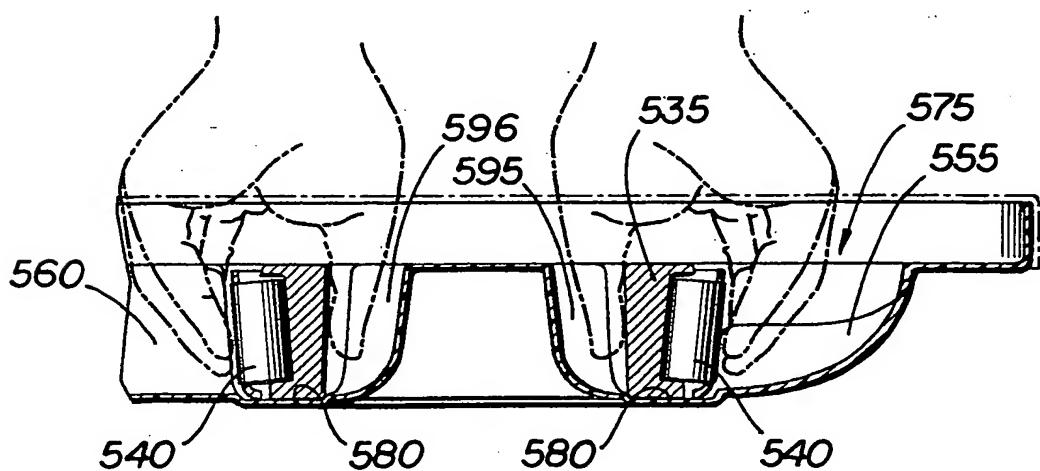
**FIG 3****FIG 4**

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100'



**FIG 5**

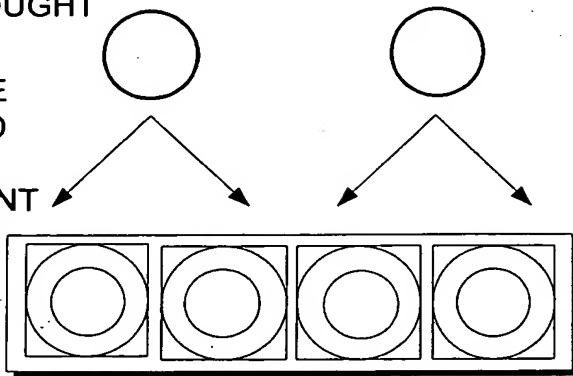


**FIG 6**

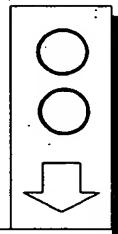
## TEARING DOWN OF WHEEL ASSEMBLIES

WORN WHEEL ASSEMBLIES BROUGHT TO SHOP  
BEARINGS ARE REMOVED AND PLACED ON RACKS THEN SENT TO CLEANING

705



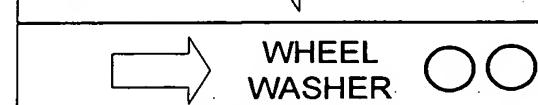
WHEEL HALVES ARE PLACED ON CONVEYERS TO BE CLEANED, INSPECTED, SQUAWKED AND PIECE PARTS ARE INSTALLED



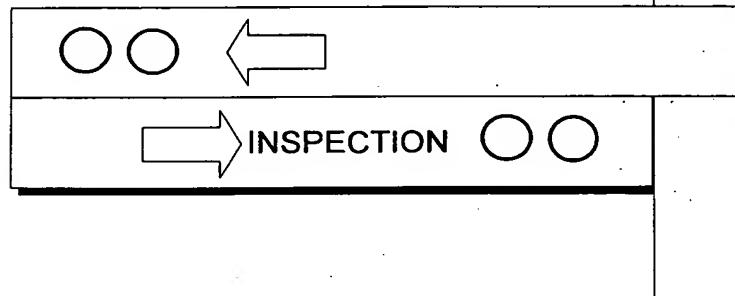
710

CLEANING SHOP

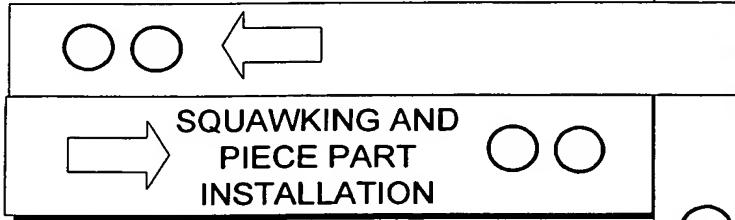
BEARINGS ARE CLEANED AND DRIED IN BEARING WASHER



WHEEL WASHER



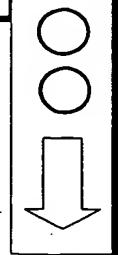
INSPECTION



SQUAWKING AND PIECE PART INSTALLATION

BEARINGS SENT TO STATION 720 ON FIG. 7B

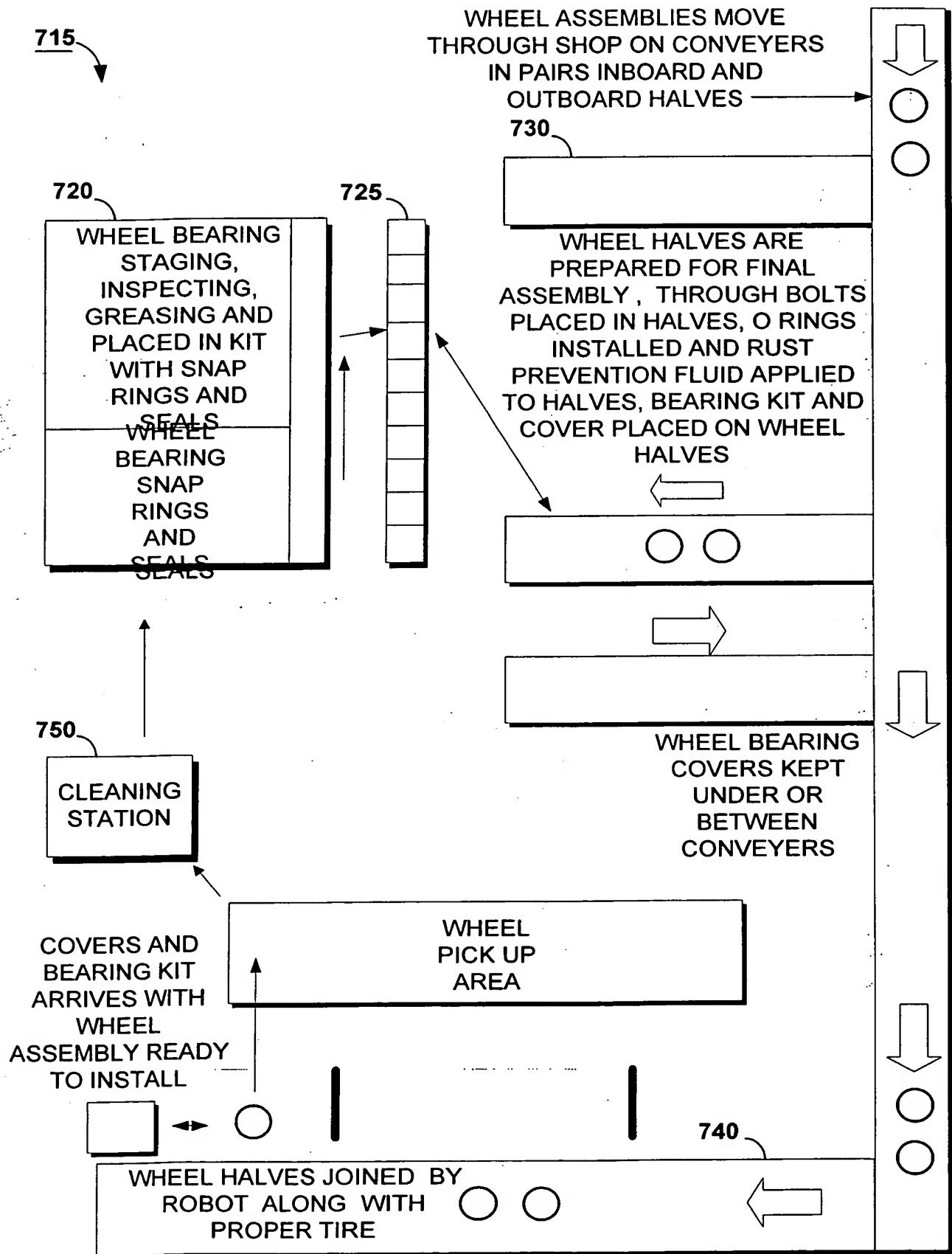
WHEELS SENT TO BUILD UP FOR FINAL ASSEMBLY ON ROBOT



**FIG 7A**

700

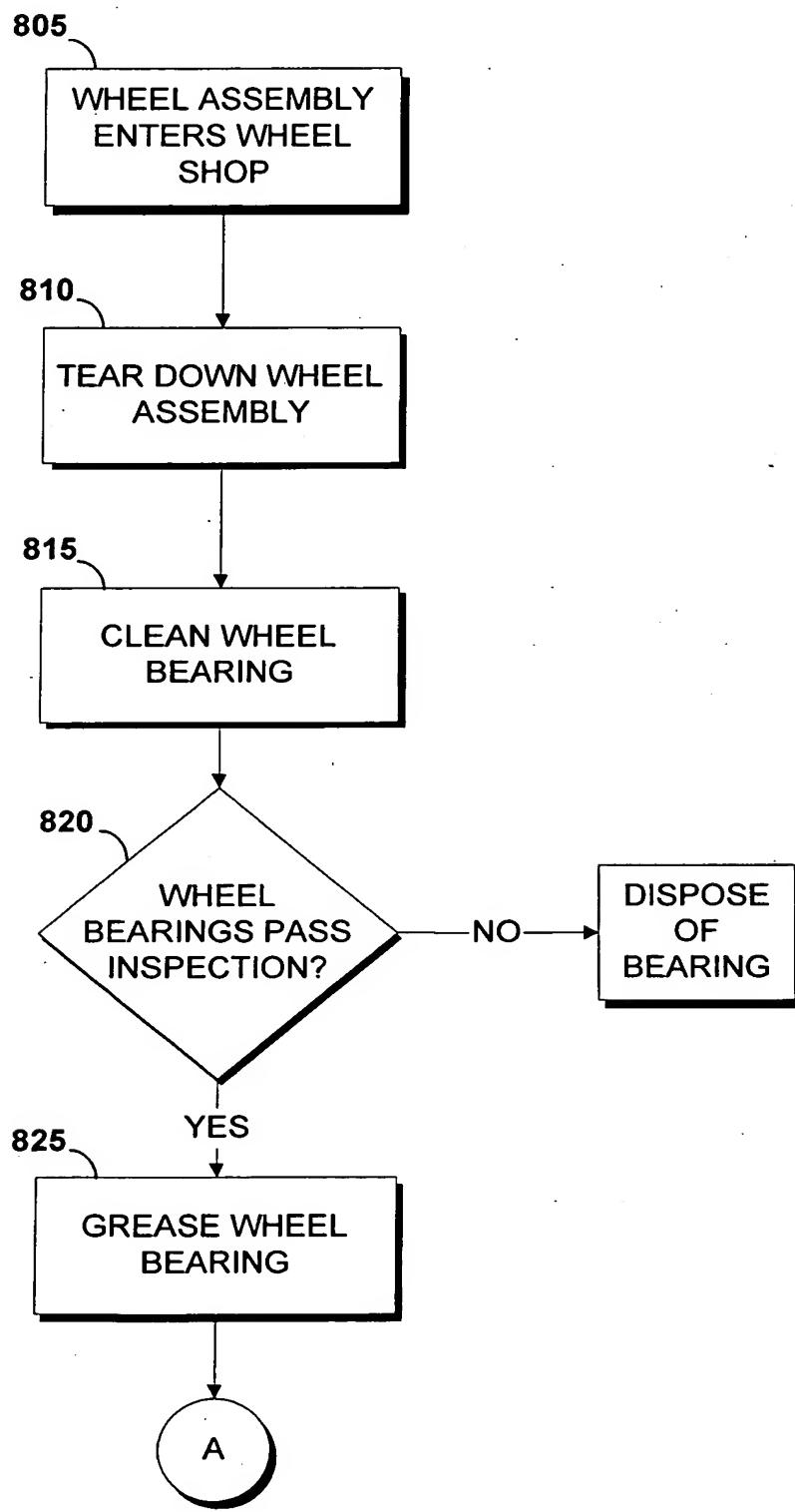
## CONSTRUCTING WHEEL ASSEMBLIES



**FIG 7B**

## RECYCLING USED WHEEL BEARINGS

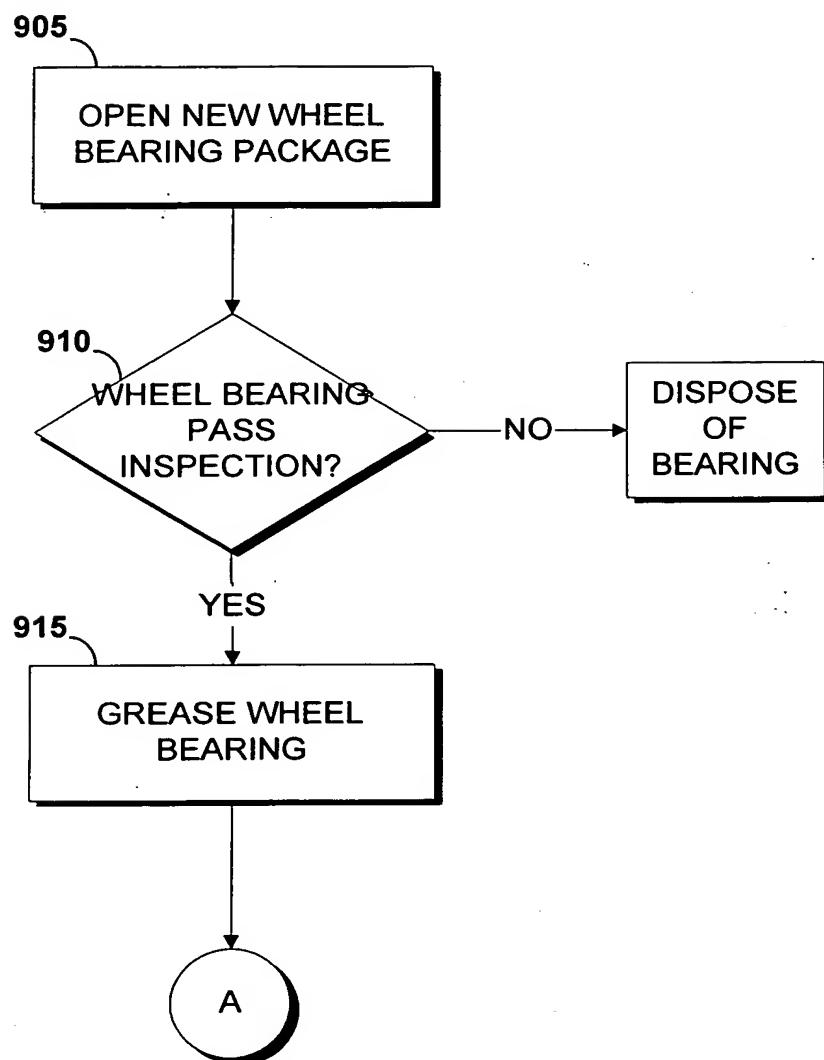
800



**FIG 8**

## INCORPORATING NEW WHEEL BEARINGS

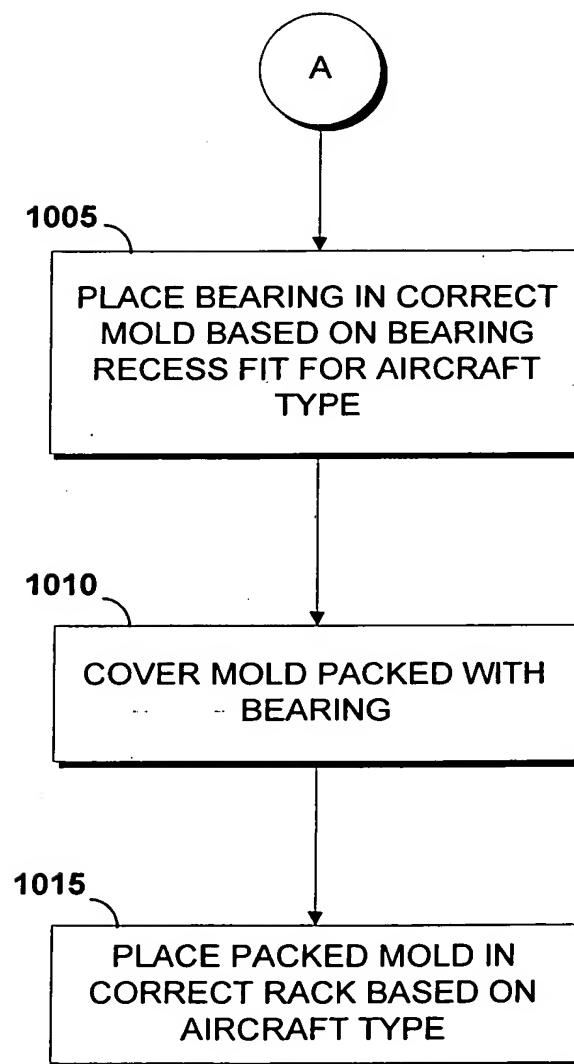
900



**FIG 9**

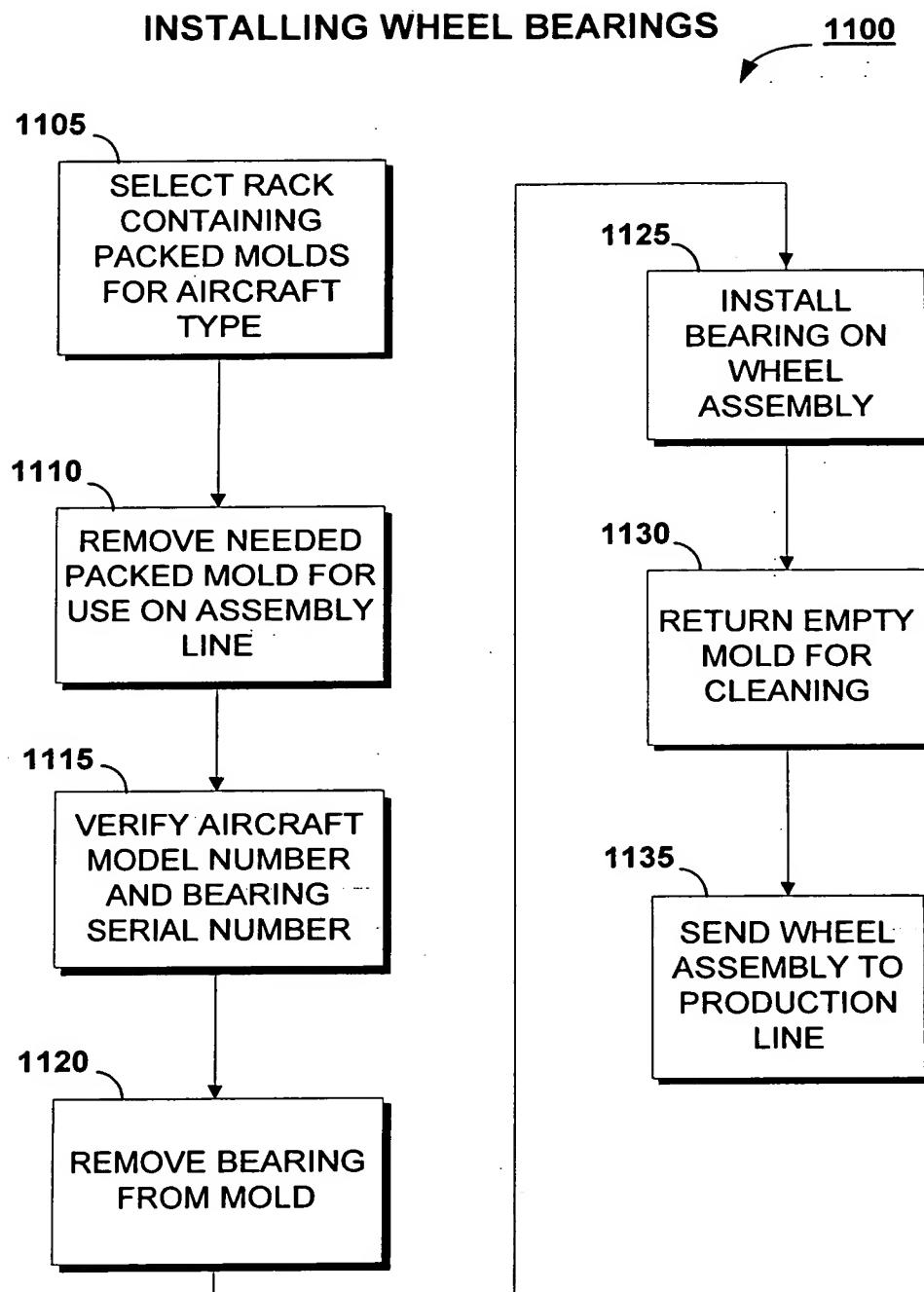
## PACKING WHEEL BEARINGS INTO MOLDS

1000



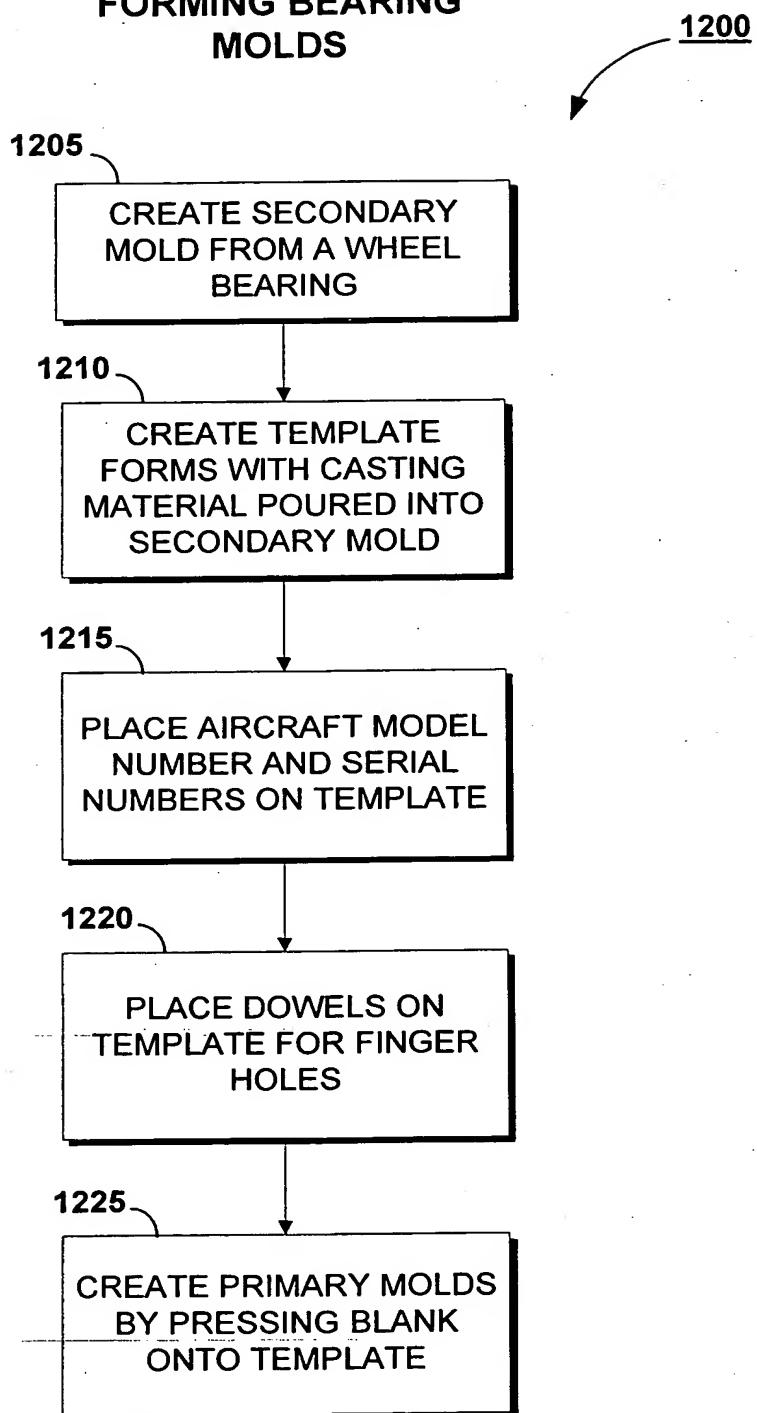
**FIG 10**

## INSTALLING WHEEL BEARINGS



**FIG 11**

## FORMING BEARING MOLDS



**FIG 12**